

Work Order ID 87026

87026

Page 1

July-10-12 7:08:18 AM

Item ID: D412-742-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 7/10/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-742	E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013

CHG007

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
16
9-83

17/4/13
JB

12/7/10

1

12/07/11 JB

DAS
16
9-83

12/4/13

EL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87026

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July-10-12 7:08:18 AM

Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Float Skidtube Installation
 Start Date: 7/10/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: 73								
140		0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

W 12.07.30

W/O:		WORK ORDER CHANGES					
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Work Order ID: 87026

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13New Issue KJ/JLM
 IPP Rev:B 06-06-08 As per DSI9336 JLM 1072 DD verified by:JLM
 IPP Rev:D 08-09-08 ccn 08-510 DD verified by:EC
 IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13 verified by:EC
 IPP Rev:G 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP rev:H 12.01.12 PER IIN REV.E DD VERF: DD 12.03.14 verified by:EC
 IPP RevC 07-12-03 ECN IPP Rev:I add AN4C47A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A Bolt		Purchased	No			110	Each	128.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST361		128							
				118451		6							
				119798		2							
				121009		22							
				121585		2							
				122012		46			122012				
				122204		50							
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1				
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		1							
				11644		1							
				ST425		-13							
				ST432		6							
				85883		6			85883				
				ST433		13							

5
12/10/12

B 86502.5P
 12/07/11

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2572
Saddle, Fwd In 205

Manufactured No

110 Each 7.0000

1

1

✓ JB

h

Location

Loc Qty

Loc Code

ST432

7

71107

2

85882

5

85882

D2573
Saddle, Aft Out 205

Manufactured No

110 Each 3.0000

1

1

✓ JB

h

Location

Loc Qty

Loc Code

ST423

-12

79424

0

ST433

3

83669

3

83669

ST434

12

D2574
Saddle, Aft In 205

Manufactured No

110 Each 3.0000

1

1

✓ JB

h

Location

Loc Qty

Loc Code

ST433

3

83671

3

83671

D2876
Saddle Spacer

Manufactured No

110 Each 94.0000

2

2

✓ JB

h

Location

Loc Qty

Loc Code

ST020

94

83323

40

83890

54

83890

D2877
Saddle Spacer

Manufactured No

110 Each 64.0000

2

2

✓ JB

12/07/11

✓

Location

Loc Qty

Loc Code

ST020

64

83324

3

83891

61

1X 83324

1X 83891

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 87026

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3403-1 Bushing	Manufactured	No	110	Each	65.0000	8	8	JB	L
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST041			15			
			70696			15			
			ST042			50			
			80208			7			
			80219			4			
			85661			39		85661	
D3403-5 Bushing	Manufactured	No	110	Each	45.0000	8	8	JB	L
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST042			45			
			85664			45		85664	
D2747 Set Screw	Manufactured	No	110	Each	96.0000	4	4	JB	L
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST017			96			
			79520			5			
			81877			91		81877	
D3533-1 Set Screw	Manufactured	No	110	Each	68.0000	2	2	JB 12/07/10	L
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST053			68			
			80326			2			
			83892			66		83892	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 87026

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

AN4C6A Purchased No 110 Each 423.0000 16 16 - JB

Bolt

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	419	
116704	2	
120423	1	
121657	416	

AN4C53A Purchased No 110 Each 105.0000 4 4 - JB

Bolt

Location	Loc Qty	Loc Code
ST361	105	
122193	99	
122194	6	

AN4C52A Purchased No 110 Each 8.0000 4 4 - JB

BOLT

Location	Loc Qty	Loc Code
ST361	8	
117688	6	
120364	2	

AN6C12A Purchased No 110 Each 48.0000 8 8 - JB

BOLT

Location	Loc Qty	Loc Code
ST341	48	
121541	7	
122204	41	

D3672-3 Manufactured No 110 Each 811.0000 32 32 - JB 12/07/10

Phenolic Washer

Location	Loc Qty	Loc Code
ST060	811	
84361	311	
84432	500	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87026

Parent Item: D412-742-013

Start Date: 7/10/12

Required Date: 8/03/12

Parent Item Name: Float Skidtube Installation

Start Qty: 1.00

Required Qty: 1.00

6	AN960C416L	NAS1149 C0432R	Purchased	No	110	Each	0.0000	32	121225	32	JB	u
	WASHER											
6	D3672-9		Manufactured	No	110	Each	308.0000	8	8	8	JB	
	Phenolic Washer											
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			ST060		308							
			81763		308				81763			
5	NAS1149C0632R		Purchased	No	110	Each	183.0000	8	8	8	JB	u
	WASHER											
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			ST297		183							
			119736		2							
			120308		1							
			121825		180				121825			
5	D3672-11		Manufactured	No	110	Each	203.0000	8	8	8	JB	u
	Phenolic Washer											
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			ST060		203							
			77483		203				77483			
5	MS21043-4		Purchased	No	110	Each	1,779.0000	29	29	29	JB	12/07/10
	Nut											u
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			FG		40							
			104603		40							
			ST301		739							
			119546		4							
			121162		295				121162			
			121652		440							
			ST318		1000							
			122141		1000							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 87026

Parent Item: D412-742-013

Start Date: 7/10/12

Required Date: 8/03/12

Parent Item Name: Float Skidtube Installation

Start Qty: 1.00

Required Qty: 1.00

6	D3403-3 Bushings	Manufactured	No	110	Each	52.0000	8	8	JB	✓
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				ST042		52				
				85662		52		85662		
5	D3405-041 Lug Assembly	Manufactured	No	110	Each	13.0000	1	1	JB	✓
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				ST478		13				
				62227		2				
				77000		2				
				83370		3		83370		
				83896		6				
5	D3405-043 Lug Assembly	Manufactured	No	110	Each	8.0000	1	1	JB	✓
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				ST478		8				
				82038		1				
				83897		7		83897		
6	AN4C7A Bolt	Purchased	No	110	Each	123.0000	4	4	JB	✓
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				ST356		123				
				109147		123		109147		
5	D3407-041 Tow Ring	Manufactured	No	110	Each	2.0000	1	1	JB	12/07/10
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
				ST463		2				
				82068		2		82068		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 87026

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3417-3 Washer Manufactured No 110 Each 21.0000 2 2 ✓ JB C

Location Loc Qty Loc Code

FG 9

33519 9

ST042 12

80225 12

D3456-1 Washer Manufactured No 110 Each 215.0000 1 1 ✓ JB C

Location Loc Qty Loc Code

FG 7

25701 7

ST044 208

80252 1

81876 15

83584 92

85223 100

AN3C37A BOLT Purchased No 110 Each 154.0000 1 1 ✓ JB C

Location Loc Qty Loc Code

ST324 50

122204 50

ST354 104

116874 11

117010 2

120422 3

121068 36

121584 2

121585 50

AN3C40A BOLT Purchased No 110 Each 20.0000 1 1 ✓ JB 12/07/12 C

Location Loc Qty Loc Code

ST354 20

114442 20

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Page 8

Work Order ID: 87026

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

8 AN3C41A
BOLT

Purchased No

110 Each 211.0000

1 1 JB

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	207	
121013	26	121013
121313	80	
121689	1	
122241	100	

5 AN3C42A
BOLT

Purchased No

110 Each 69.0000

1 1 JB

Location	Loc Qty	Loc Code
ST354	69	
106176	1	
120464	1	
121103	17	121103
122241	50	

5 AN3C43A
BOLT

Purchased No

110 Each 61.0000

4 4 JB

Location	Loc Qty	Loc Code
ST354	61	
114455	2	
119673	1	
120465	58	120465

5 AN3C46A
BOLT

Purchased No

110 Each 51.0000

5 5 JB 12/07/10

Location	Loc Qty	Loc Code
ST355	51	
120447	3	
122204	48	122204

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Start Date: 7/10/12

Required Date: 8/03/12

Parent Item Name: Float Skidtube Installation

Start Qty: 1.00

Required Qty: 1.00

S AN960C10L washer NAS1149C0332R Purchased No

110 Each 21.0000

26 26

122063

JB

u

Location

Loc Qty

Loc Code

ST

21

107534

21

S MS21043-3 Nut Purchased No

110 Each 1,096.0000

13

13

u

JB 12/07/10

u

Location

Loc Qty

Loc Code

FG

72

103691

77

ST301

1024

118077

2

118614

12

118686

30

119758

20

121255

103

121708

857

121255

W/O:		WORK ORDER CHANGES					
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